

Sept-12

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:19:44 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STOP
Job Number :	28182		
Estimate Number :	10515		
P.O. Number :	N/A	Part Number :	D28053
This Issue :	15/08/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2805 REV. B
First Issue :	N/A	Project Number :	N/A
Previous Run :	25715	Drawing Revision :	B
	Type :	Material :	N/A
	MACHINED PARTS	Due Date :	08/09/2006
Written By :			Qty: 16 Um: Each
Checked & Approved By :			
Comment :	Est: A 01.03.21 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01500	6061-T6 Bar 1.5" x 1.5"
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Comment: Qty.: 0.2756 f(s)/Unit Total : 4.4100 f(s)

6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5"

(M6061T6B1500X01500)

Batch: 1616954

J.G

06/08/16

16

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut Bar: 3.150" Long +0.010/-0.030"

J.G

06/08/16

16

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA104 and Dwg D2805

2- Tumble and Deburr

Identify as D2805-3

mk 06/08/19

16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 06/08/19

16

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Er 06/08/20

x16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 21/08/27

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:19:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 28182

Part Number: D28053

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-08-22

(16)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

AL 06/08/23

(16)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST387*

AL 06/08/23

(16)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06.08.24

Job Completion



u 2608.73

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

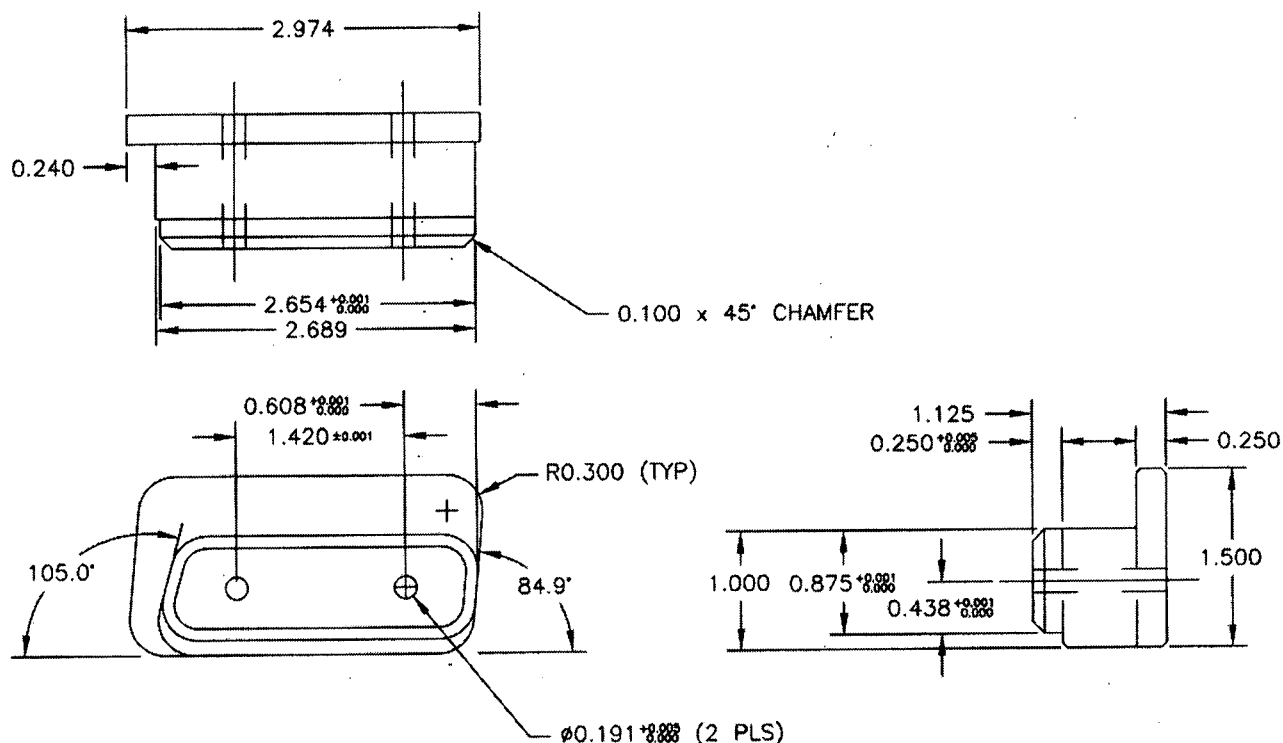
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY LP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
01.03.16 #



REFERENCE ONLY

D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

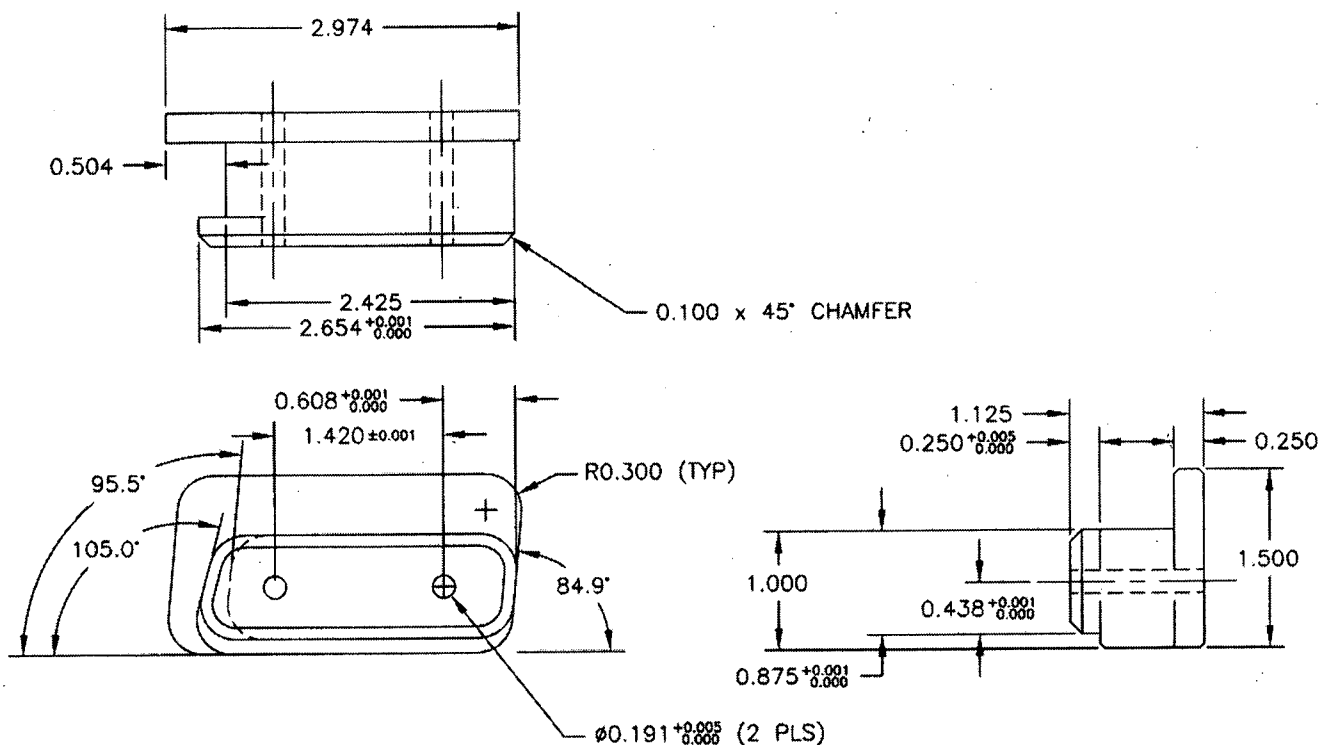
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DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED
01.03.16



D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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